

Work Order ID 82748

April-05-12 12:58:39 PM

82748

Page 1

Item ID: D3601-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Radius Block
Start Date: 05/04/2012 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 20/04/2012 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/04/15 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3601 | Rev A | | | | | | | | |
| 100 | SHEAR | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Shear | Memo | 0.00 | | | | | | | |
| Shear | blanks 9.00" long +/- 0.030" Note: 1 blank makes 8 pieces | | | | | | | | |
| 110 | HAAS CNC VERTICAL MACHINING #1 | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | 1- Mill as per Folio FA682 Rev: <u>AA</u> & Dwg D3601 Rev: <u>A</u> | | | | | | | | |
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

FK 12/04/15

40 0

40 0

12/04/18

40 0

12/04/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 82748

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Item ID: D3601-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Radius Block

Start Date: 05/04/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | Small Fab | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1-Tumble ✓ 2-Deburr any rough edges after tumbling ✓ | | | | | | | | |
| 150 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

22 12-4-18 40 1

40 12-4-19

40 12-4-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Item Name: Radius Block

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Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 40.00

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location: <u>056</u> | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

40 x 4 M u l o 4 / 1 9

40 12/04/2012 B

12/4/23

MF
12-04-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

April-05-12 12:58:44 PM

Page 1

Work Order ID: 82748

82748

Parent Item: D3601-1

D3601-1

Parent Item Name: Radius Block

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-03-28 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B00750X00.1 25 | | Purchased | No | | | | f | 77.9680 | | 2.664 | | | |

M6061T6B00750X00 125

6061-T6 Bar .750 x .125

**

FK 12/04/15

Location

Loc Qty

Loc Code

MAT001

11.168

116406

2.75

117653

8.418

MAT003

66.8

119653

41.4

120603

25.4

2.665

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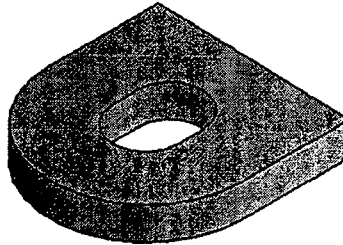
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

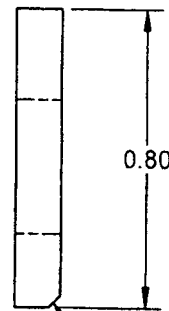
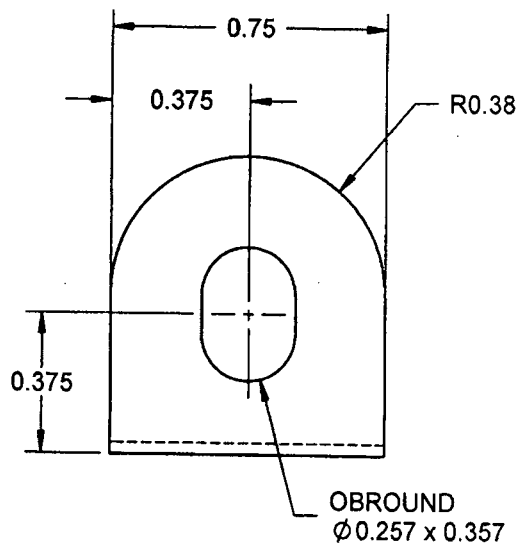
DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CB</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3601 | REV. A SHEET 1 OF 1 |
| DATE 07.02.13 | | TITLE RADIUS BLOCK SCALE 2:1 | |
| REV A | DATE 07.02.13 | DESCRIPTION NEW ISSUE | |

RELEASED

07.03.08 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82348 MJS
12/04/05



CHAMFER 0.05
0.03 x 45° OR
FILLET R 0.05
0.03

D3601-1 RADIUS BLOCK**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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